Date:

Wednesday, 3/14/2007 3:32:02 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 31227

Job Number **Estimate Number**

: 10764

P.O. Number

:NA

This Issue

Previous Run

: 3/14/2007

Prsht Rev. First Issue

: NC

: 29789

: 3/14/2007

S.O. No. : N/A

Type

: SMALL /MED FAB

Drawing Number Project Number

Material

Due Date

Part Number

Drawing Name

. D2876 REV B : N/A

Drawing Revision

: NOTE:1 BLANK MAKES 4 PARTS

: SADDLE SPACER

: 4/6/2007

: D2876

Qty:

120 Um:

Each

Written By **Checked & Approved By**

Comment

: Esr Rev:B 00.05.19 Est Rev:C

Added inspect level 8 EC

Now M6061-T6 06-06-23

JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S100

6061-T6 .100 Sheet

Comment: Qty.:

0.0542 sf(s)/Unit Total:

6.5016 sf(s)

Material: 6061-T6 (QQ-A-250/8) 0.100" Thick Batch: M107 206

FLOW WATER JET

2.0

WATER JET

Comment: FLOW WATER JET

SAD

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



4.0

PARTS AS THEY COME OFF MACHINE



Comment: INSPECT

SECOND CHECK



Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1



120

5.0

SMALL FAB



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tabs and Tumble



6.0

HAND FINISHING1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1





Dart Aerospace Ltd

W/O:	- 11-11 1	WORK ORDER CHAI	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
				,							
•											
	1										

Part No:	PAR #:	Fault Category:	 NCR: Yes No	DQA:	Date:	07/03/2
			QA: N/C C	losed:	Date:	

NCR:		,	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	A	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
								1		

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:32:02 PM User: Kim Johnston **Process Sheet** Drawing Name: SADDLE SPACER Customer: CU-DAR001 Dart Helicopters Services Part Number: D2876 Job Number: 31227 Job Number: Seq. #: **Description: Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 07/03/29 Comment: FINAL INSPECTION/W/O RELEASE N N. 03, 29 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
	,		·								
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date:					

QA: N/C Closed: ____ Date: ____

	WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B		Varification	Approval Chief Eng	Ammassal	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector	
							}	
	STEP	Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Section B Initial Action Description Sign & Section C	STEP Description of NC Section A Section B Section B Verification Approval Chief Eng	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31227
Description: Saddle Spacer	Part Number:	D2876
Inspection Dwg: D2876 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.98	+/-0.030	0.98	1		Vern	
1.00	+/-0.030	0. 998	/		Vera	
Ø0.257	+0.005/-0.000	Ø0.260			Vern Heisth	
3.35	+/-0.030	3.36	<u></u>		Heisth	
2.48	+/-0.030	2.47			Heightgange	
0.555	+/-0.010	0.554			Height cause	
0,100	+1-0.010	6.095			Vern	

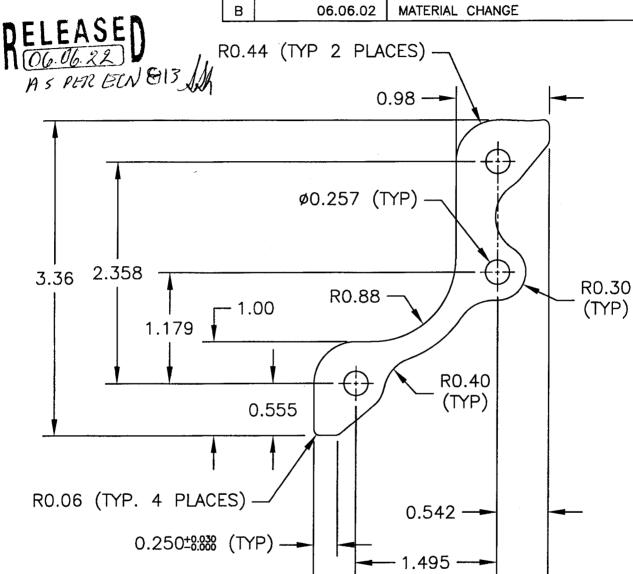
Measured by: 5AV)	Audited by:	Prototype Approval:	N/A
Date: 07/63/18	Date: 07/03/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.12.15	New Issue	KJ/RF	
В	04.06.15	Removed 0.250 dimension	KJ/JLM	
С	06.06.23	Dwg Rev. changed	KJ/JLM	



DRAWN BY DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. B CHECKED APPROVED D2876 SHEET 1 OF 1 TITLE SCALE DATE 06.06.02 SADDLE SPACER **NEW ISSUE** 99.02.23 Α

2.48



NOTES:

1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK

(REF DART SPEC M6061T6S.100)

5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK (REF DART SPEC M5052H32S.100)

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

ALL DIMENSIONS ARE IN INCHES

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

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